

Work Order ID 86907

July-09-12 10:57:53 AM

86907

Page 1

Item ID: D3204-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Release Pedal Assembly
 Start Date: 7/09/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3204	Rev A1								

100 0.00
100 Large Fab
 Large Fab Memo 0.00
 Large Fab 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.
 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.

4 EL 12-7-17

110 0.00
110 QC9- Inspect visual per QSI004- Fusion Welds
 QC Memo 0.00
 Quality Control

4 Ø 12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(44)			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4X			M/L 12/07/18
140 *140* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo ***Cover holes for bushing*** START TIME: 12:00 OVEN TEMPERATURE: 320°F FINISH TIME: 12:30	0.00 0.00				4X			M/L 12/07/18

M121279

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150						4	6	12/02/18	
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Small Fab					4		12/07/18	
Small Fab	Memo	0.00							
Small Fab	Install D3204-7 bushing as shown in Dwg D3204								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									

D4
800 12/08/18

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Packaging Packaging	Identify as per dwg & Stock Location <i>GA</i> Memo	0.00 0.00				<i>4K</i>			<i>12/07/12</i>
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/7/20</i> <i>mf</i> <i>12-07-19</i>

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Picklist Print

July-09-12 10:57:52 AM

Page 1

Work Order ID: 86907

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 7/09/12

Required Date: 8/10/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Part	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 Tube		Manufactured	No	86968X4		100	Each	0.0000	1	6		12-7-17	
D3204-11 Plate		Manufactured	No			100	Each	4.0000	1	6		12-7-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		4							
				57522		4				4			
D3204-13 Gusset		Manufactured	No			100	Each	22.0000	2	12		12-7-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		16							
				85984		16X1				1			
				WA021		6							
				70315		3							
				73465		X 7				7			
D3204-3 Arm		Manufactured	No			100	Each	9.0000	1	6		12-7-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA019		9							
				79801		9				4			
D3204-5 Arm		Manufactured	No			100	Each	8.0000	1	6		12-7-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				85982		8				4			

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Work Order ID: 86907

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 7/09/12

Required Date: 8/10/12

Start Qty: 6.00

Required Qty: 6.00

D3204-7
Bushings

Manufactured No

160 Each 49.0000

2 12

Handwritten: 12/07/18

Location

Loc Qty

Loc Code

GA

49

77091

1

85981

48

Handwritten: 8

D3204-9

Pedal

Manufactured No

100 Each 13.0000

1 6

Handwritten: 12-7-17

Location

Loc Qty

Loc Code

WA

10

85980

10

WA020

3

79803

3

Handwritten: 85980

Handwritten: x1

Handwritten: 3

Handwritten: 1

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Shop Packet Print

Page 2

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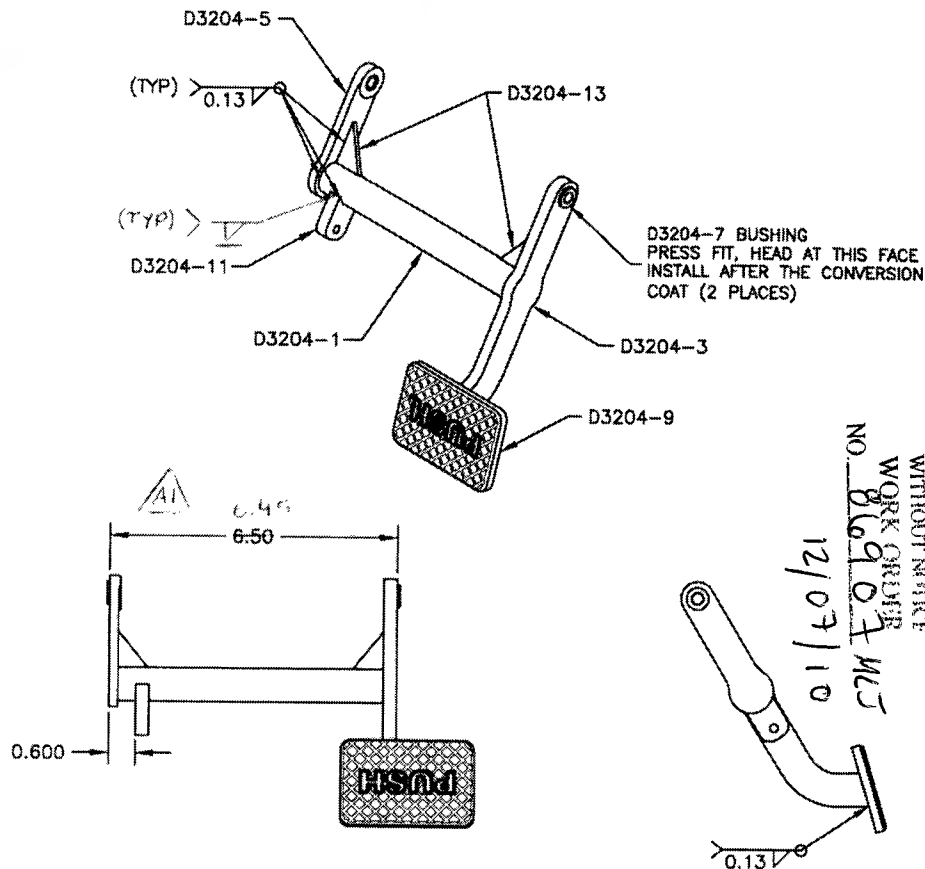
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DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
AI	#	05.07.15	6.45 WAS 6.50

RELEASED
04.04.30



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86907 MJS
12/07/10

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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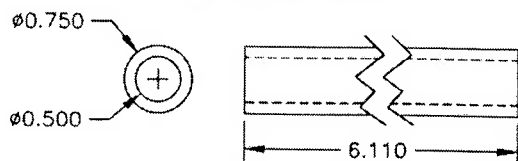
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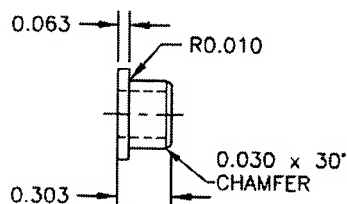


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

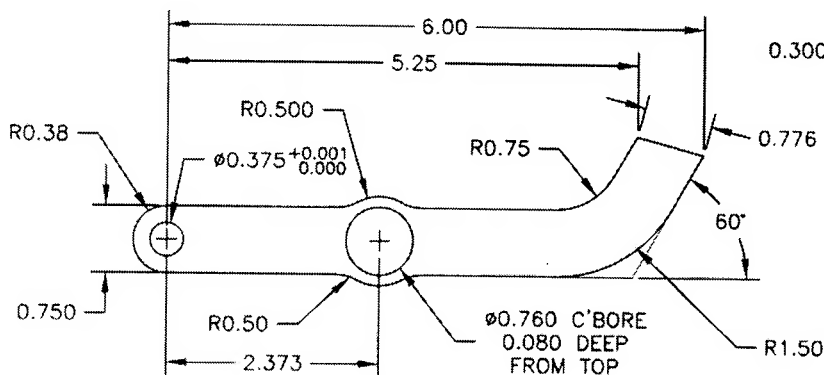
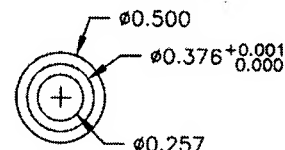
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04.04.05



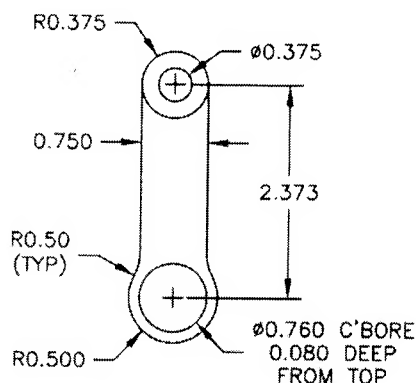
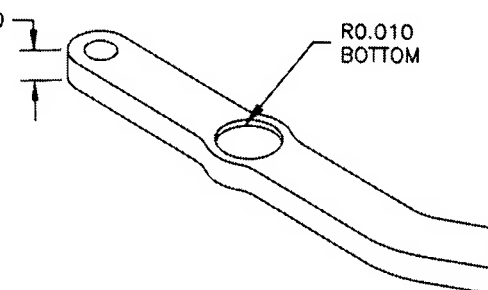
2 D3204-1 TUBE
SCALE 1:2



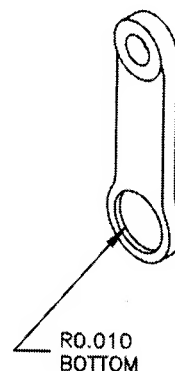
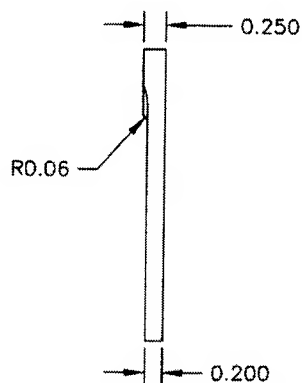
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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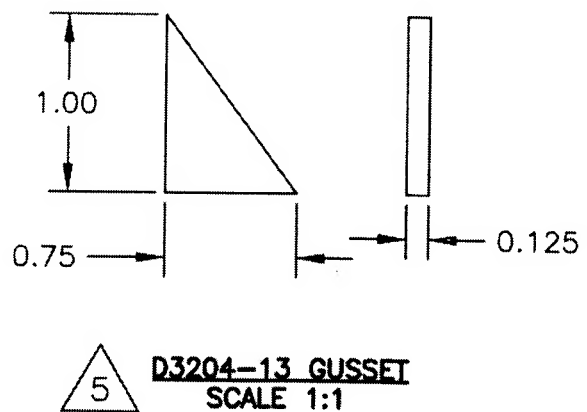
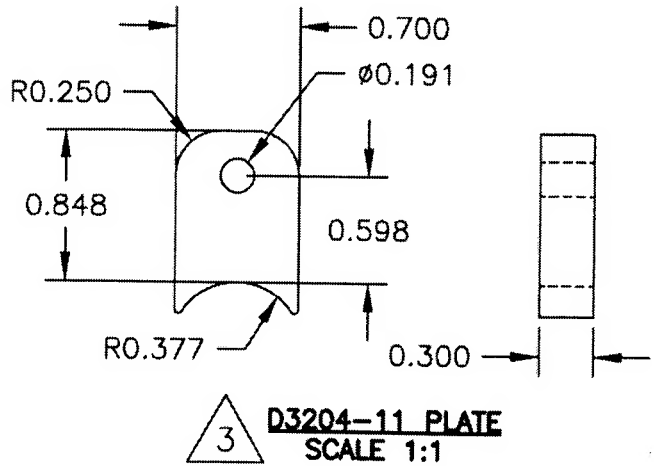
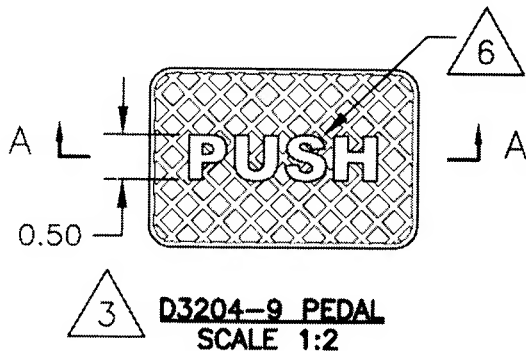
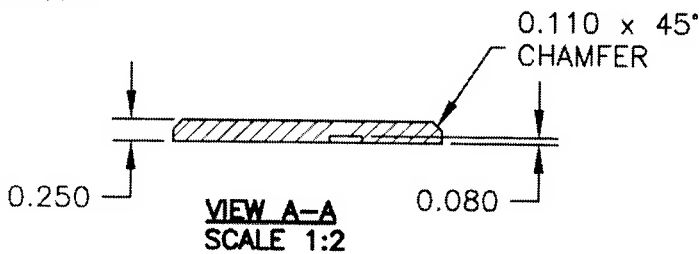
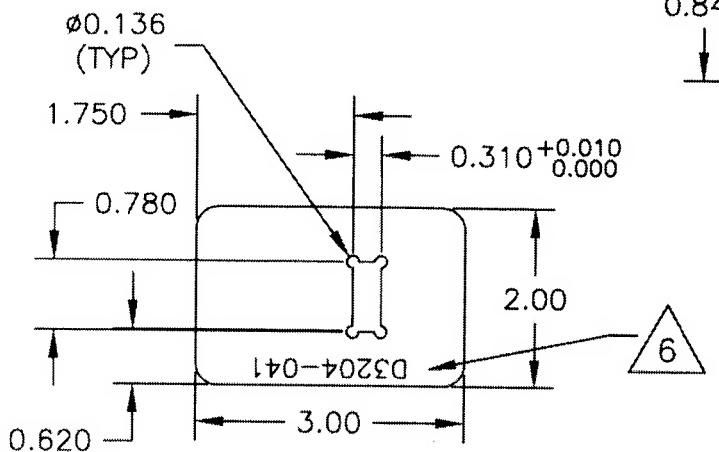
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04 04 30



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